



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

29 JUNE
Glossy Black

D4272-012
Job Sheet 177997



Part No: D4272-012

Job Qty: 1 ea

Part Name: Basket Assembly, Heavy Duty Lid, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/24/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A 10.11.19 new issue DD verf:EC IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Stores/Pkg-1		JUL 18-7-04
100	Packaging	1 pcs	6/29/18	6/29/18	0.00	0.00	Packaging1-5		JUL 18-7-04
110	HandFinish	1 pcs	6/29/18	6/29/18	0.00	2.04	HandFinish4		JUL 18-7-04
120	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		38
130	Packaging	1 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-2		16 2018
140	QC21-SA	1 Ea	6/29/18	6/29/18	0.00	0.00	QC21		16 2018

Part Op 110 - TRANSFER DRILL FROM PLACARD INTO BASKET AS PER DWG ON SHEET 1 ASSEMBLE USING BARE
Descriptions: D4273-042 X 1 B75294 FROM BASKET D407-797-014 X 1 B131540

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97447A010	Blind Rivet	4 pcs (4 ea)	90-Start up Operation	5019014
AN3-10A	Bolt	3 Ea (3 ea)	90-Start up Operation	5062291
AN3-14A	Bolt	4 Ea (4 ea)	90-Start up Operation	5067270
AN3-16A	Bolt	2 Ea (2 ea)	90-Start up Operation	5045859
AN310-4	Nut	3 Ea (3 ea)	90-Start up Operation	5060062
AN310C4	Nut	3 Ea (3 ea)	90-Start up Operation	5057494
AN4-12	Bolt	3 Ea (3 ea)	90-Start up Operation	5064082
AN4-13A	Bolt	6 Ea (6 ea)	90-Start up Operation	5067892
AN4C15	Bolt 5053946	1 Ea (1 ea)	90-Start up Operation	5068640
AN5-17A	Bolt	4 Ea (4 ea)	90-Start up Operation	5068075
D2530	Handle Weldment	1 Ea (1 ea)	90-Start up Operation	5063832
D2535	Spring	2 Ea (2 ea)	90-Start up Operation	5050159
D2537	Bushing	2 Ea (2 ea)	90-Start up Operation	5081355
D2690-6	Lanyard	2 Ea (2 ea)	90-Start up Operation	FR6435
D2931	Bumper	2 Ea (2 ea)	90-Start up Operation	5069248
D3912-041	Eyebolt Receiver Assembly	1 Ea (1 ea)	90-Start up Operation	X 5075267
D3914-041	Long Basket Lid Assembly (350) 5080830	1 Ea (1 ea)	90-Start up Operation	5067458
D3917-3	Washer	6 Ea (6 ea)	90-Start up Operation	5051316
D3953-17	Gas Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5051311
D3953-19	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	
D3953-21	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	
D3953-3	Gas Spring Stud, Lid	2 Ea (2 ea)	90-Start up Operation	5075157

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Misidentified ☐	Past Due ☐	OTHER :																							

D3953-7	Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5059063
D3953-9	Gas Spring Washer	2 Ea (2 ea)	90-Start up Operation	5075339
D3969-3	Spring (Basket Lid)	1 Ea (1 ea)	90-Start up Operation	5069097
D4021-5	Blanking Plate	1 Ea (1 ea)	90-Start up Operation	5083734
D4150-041	Attachment Arm Assembly	1 Ea (1 ea)	90-Start up Operation	5075972
D4151-041	Basket Fwd Hardpoint Assembly, Lower	1 Ea (1 ea)	90-Start up Operation	5082763
D4151-043	Basket Fwd Hardpoint Assembly, Upper	1 Ea (1 ea)	90-Start up Operation	5080826
D4273-042	Basket Base Assembly, RH	1 Ea (1 ea)	90-Start up Operation	5072297
D4307-250	Placard, Max Load	1 Ea (1 ea)	90-Start up Operation	5057521(1)
MS17984-C413	Quick Release Pin (1x) 5068658	2 pcs (2 ea)	90-Start up Operation	5076007
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	90-Start up Operation	5078167
MS21042L3	Nut	9 Ea (9 ea)	90-Start up Operation	5078254
MS21042L4	Nut	6 Ea (6 ea)	90-Start up Operation	5041167
MS21042L5	Nut	4 Ea (4 ea)	90-Start up Operation	5053951-1
MS24665-151	Cotter Pin	4 Ea (4 ea)	90-Start up Operation	5044180
MS24665-300	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	5050052
NAS1149C0432R	Washer	2 Ea (2 ea)	90-Start up Operation	5053953
NAS1149C0463R	Washer	3 Ea (3 ea)	90-Start up Operation	5034411
NAS1149DN832J	Washer	2 Ea (2 ea)	90-Start up Operation	5071412
NAS1149F0332P	Washer	14 Ea (14 ea)	90-Start up Operation	5054114
NAS1149F0432P	Washer 5050655	18 Ea (18 ea)	90-Start up Operation	5067901
NAS1149F0563P	Washer	4 Ea (4 ea)	90-Start up Operation	5044189
NAS1515H4L	Washer	2 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97447A010	4	738	0
	AN3-10A	3	131	0
	AN3-14A	4	242	0
	AN3-16A	2	72	0
	AN310-4	3	124	0
	AN310C4	3	133	0
	AN4-12	3	64	0
	AN4-13A	6	1,562	0
	AN4C15	1	52	0
	AN5-17A	4	234	0
	D2530	1	16	0
	D2535	2	79	0
	D2537	2	36	0
	D2690-6	2	7	0
	D2931	2	1,038	0
	D3912-041	1	10	0
	D3914-041	1	5	0
	D3917-3	6	43	0
	D3953-17	2	87	0
	D3953-19	1	48	0
	D3953-21	1	42	0
	D3953-3	2	24	0
	D3953-7	2	36	0
	D3953-9	2	17	0
	D3969-3	1	26	0
	D4021-5	1	56	0
	D4150-041	1	4	0
	D4151-041	1	8	0
	D4151-043	1	7	0
	D4273-042	1	0	0
	D4307-250	1	6	0
	MS17984-C413	2	34	0
	MS20600-AD4W3	2	203	0
	MS21042L3	9	1,563	0
	MS21042L4	6	2,734	0
	MS21042L5	4	741	0
	MS24665-151	4	381	0
	MS24665-300	2	88	0
	NAS1149C0432R	2	2,257	0
	NAS1149C0463R	3	251	0
	NAS1149DN832J	2	1,864	0
	NAS1149F0332P	14	3,675	0

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NAS1149F0432P	18	1,519	0
NAS1149F0563P	4	725	0
NAS1515H4L	2	325	0

Part Specifications

Specifications could not be found.

Plex 5/24/18 1:42 PM Dart.lajeunesse.marie



Container No: S088985



Part: D4272-012

Job No: 177997

Serial No/Batch: S088985

Revision:

Inspector:

Exp Date:

Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/04/18

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				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					